

Work Order ID 111395-258667

111395

Page 1

January-15-14 8:33:02 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014 Start Qty: 10.00

10

Cust Item ID:

Required Date: 28/02/2014 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date: 14-3-4

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

DAS
31
9-39

110

0.00

110

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 125127

127865

3-Grind End Plate flush

14-3-4

10

10

10.02.20

Work Order ID 111395

January-15-14 8:33:02 AM

111395

Page 2

Item ID: D350-591-312

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014 Start Qty: 10.00

10

Cust Item ID:

Required Date: 28/02/2014 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00	QC 14.2.24			10			
120		0.00							
QC	Memo								
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00	QC 14.2.24			10			
130		0.00							
QC	Memo								
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				10			
140		0.00							
HandFinish	Memo								
Hand Finishing									

Work Order ID 111395


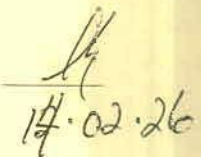
January-15-14 8:33:02 AM

111395

Page 3

Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ RH
 Start Date: 15/01/2014 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 28/02/2014 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00				10	0		
150									
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Large Fab					10	0		
Large Fab	Memo	0.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod 125/27								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

Work Order ID 111395

January-15-14 8:33:02 AM

111395

Page 4

Item ID: D350-591-312 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ RH
 Start Date: 15/01/2014 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 28/02/2014 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				(10)	14-02-27		DAS 9 9-89
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(10)	14-02-27		DAS 9 9-89
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	CF	14-2-28	

Work Order ID 111395

January-15-14 8:33:02 AM

111395

Page 5

Item ID: D350-591-312 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014 Start Qty: 10.00 *10*

Required Date: 28/02/2014 Req'd Qty: 10.00 *10*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

220

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M128027

0.00

0.00

Memo

START TIME: 12:00

OVEN TEMPERATURE: 320°

FINISH TIME: 1:30

10 4 H-3.3

DAS 34 9:59

230

230

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M128102

Memo

0.00

x 90RH 4 H 1/63/07

240

240

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

9 M14-52-04

1870-1871

1871-1872

1872-1873

1873-1874

1874-1875

1875-1876

1876-1877

1877-1878

1878-1879

1879-1880

1880-1881

1881-1882

1882-1883

1883-1884

1884-1885

1885-1886

1886-1887

1887-1888

1888-1889

1889-1890

1890-1891

1891-1892

1892-1893

1893-1894

1894-1895

1895-1896

1896-1897

Work Order ID 111395

January-15-14 8:33:02 AM

111395

Page 6

Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ RH
 Start Date: 15/01/2014 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 28/02/2014 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

10

14-3-3

DAS
6
9-89

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

14-03-03

10

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
 Location: AA1

DAS
6
9-89

9

14-3-4

8

202

Work Order ID 111395

111395

Page 7

January-15-14 8:33:02 AM

Item ID: D350-591-312 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014 Start Qty: 10.00 *10* Cust Item ID:

Required Date: 28/02/2014 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 14-03-04

MLJ 14-03-04

Picklist Print

Page 1

January-15-14 8:33:07 AM

Work Order ID: 111395

111395

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014

Required Date: 28/02/2014

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	0.0000	1	10			
D3272-1									**			14.02.20	
Step													
D3067-1		Manufactured	No			110	Each	231.0000	1	10			
D3067-1									**			14.02.20	
End Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		231							
				101785		75							
				102686		156				10			
D3219-1		Manufactured	No			110	Each	68.0000	2	20			
D3219-1									**			14.02.20	
Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		68				13			
				101508		68				8			
D3066-1		Manufactured	No			180	Each	111.0000	2	20			
D3066-1									**			14.02.20	
Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		111							
				106302		111				20			

Picklist Print

Page 2

January-15-14 8:33:07 AM

Work Order ID: 111395

111395

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014

Required Date: 28/02/2014

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

2,699.000

16

160

MS20600-AD4W4

**

Rivets

Location

Loc Qty

Loc Code

ST311

2699

125577

2699

D3065-041

Manufactured

No

180

Each

23.0000

1

10

D3065-041

**

Step Leg Assembly

Location

Loc Qty

Loc Code

WA003

23

102830

6

109447

17

D3067-1

Manufactured

No

180

Each

231.0000

1

10

D3067-1

**

End Plate

Location

Loc Qty

Loc Code

WA003

231

101785

75

102686

156

AN3-35A

Purchased

No

250

Each

53.0000

2

20

AN3-35A

**

Bolt

Location

Loc Qty

Loc Code

FG

10

122800

10

ST352

43

m127460

43

January-15-14 8:33:07 AM

Shop Packet Print

Page 2

Picklist Print

January-15-14 8:33:07 AM

Work Order ID: 111395

111395

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014

Required Date: 28/02/2014

Start Qty: 10.00

Required Qty: 10.00

D3235-1 Manufactured No

250 Each

265.0000

2 20

DAS 28
6 28
2.89 2.89

D3235-1

Mounting Lug

**

Location

Loc Qty

Loc Code

ST470

265

101559

53

102818

26

105939

106

108670

80

7x
13x

D3278-041 Manufactured No

250 Each

43.0000

1 10

DAS 28
28 28
9.89 9.89

D3278-041

Support Assembly

**

Location

Loc Qty

Loc Code

ST470

43

102349

1

108737

22

109406

20

10x

NAS1149D0463J Purchased No

250 Each

7,758.000

16

160

NAS1149D0463.1

WASHER

**

14-2-26

Location

Loc Qty

Loc Code

ST294

3358

M127693

3358

ST510a

4400

M127813

1400

M127904

3000

160x

DAS 28
28 28
9.89 9.89

Picklist Print

January-15-14 8:33:07 AM

Page 4

Work Order ID: 111395

111395

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014

Required Date: 28/02/2014

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0563J

Purchased

No

250

Each

701.0000

4

40

NAS1149D0563.1

**

Washer

Location

Loc Qty

Loc Code

GA

273

m125807

273

ST510a

428

m126319

428

AN5-36A

Purchased

No

250

Each

210.0000

2

20

AN5-36A

**

Bolt

Location

Loc Qty

Loc Code

ST338

10

M126105

10

st503

200

M127410

100

M127460

100

D2618

Manufactured

No

250

Each

360.0000

2

20

D2618

**

Bushing

Location

Loc Qty

Loc Code

ST013

360

101708

22

103863

112

108671

100

97780

126

Picklist Print

January-15-14 8:33:07 AM

Page 5

Work Order ID: 111395

111395

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014

Required Date: 28/02/2014

Start Qty: 10.00

Required Qty: 10.00

D2230-3

Manufactured No

250

Each

401.0000

4

40

D2230-3

Mounting Lug

**

Location

Loc Qty

Loc Code

FG

3

89045

3

ST469

398

105940

160

108668

238

B109344-12X

D2856-400

Manufactured No

250

f

199.0000

1.2

12

D2856-400

Abrasion Strip 4" Wide (Per Foot)

**

Location

Loc Qty

Loc Code

ST403

199

109578

199

12X

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250

Each

5,733.000

2

20

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST506

962

123900

962

ST509

4771

M127304

1000

M127410

3000

M127831

771

20

14-2-28

Picklist Print

Page 6

January-15-14 8:33:07 AM

Work Order ID: 111395

111395

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014

Required Date: 28/02/2014

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

1,560.000

8

80

**

AN4-13A

Bolt

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

17

m125709

17

ST356

42

m126193

42

ST515

1481

m126193

431

m127432

50

m127817

1000

250

Each

1,107.000

2

20

**

MS21042L5

Purchased

No

MS21042L5

Nut

Location

Loc Qty

Loc Code

GA

5

117611

5

ST314

102

125535

102

ST509

1000

m127304

500

m127813

500

Picklist Print

January-15-14 8:33:07 AM

Page 7

Work Order ID: 111395

111395

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 15/01/2014

Required Date: 28/02/2014

Start Qty: 10.00

Required Qty: 10.00

MS21042L4	Purchased	No	250	Each	4,892.000	8	80	DAS
-----------	-----------	----	-----	------	-----------	---	----	-----

MS21042L 4

Locknut

**

28
9-89

Location	Loc Qty	Loc Code
GA	80	
m126333	80	
ST509	4000	
m127255	2000	80X
m127813	2000	
ST518	812	
m127376	812	

NAS1149D0363J

Purchased

No

250

Each

3,448.000

4

40

NAS1149D0363.J

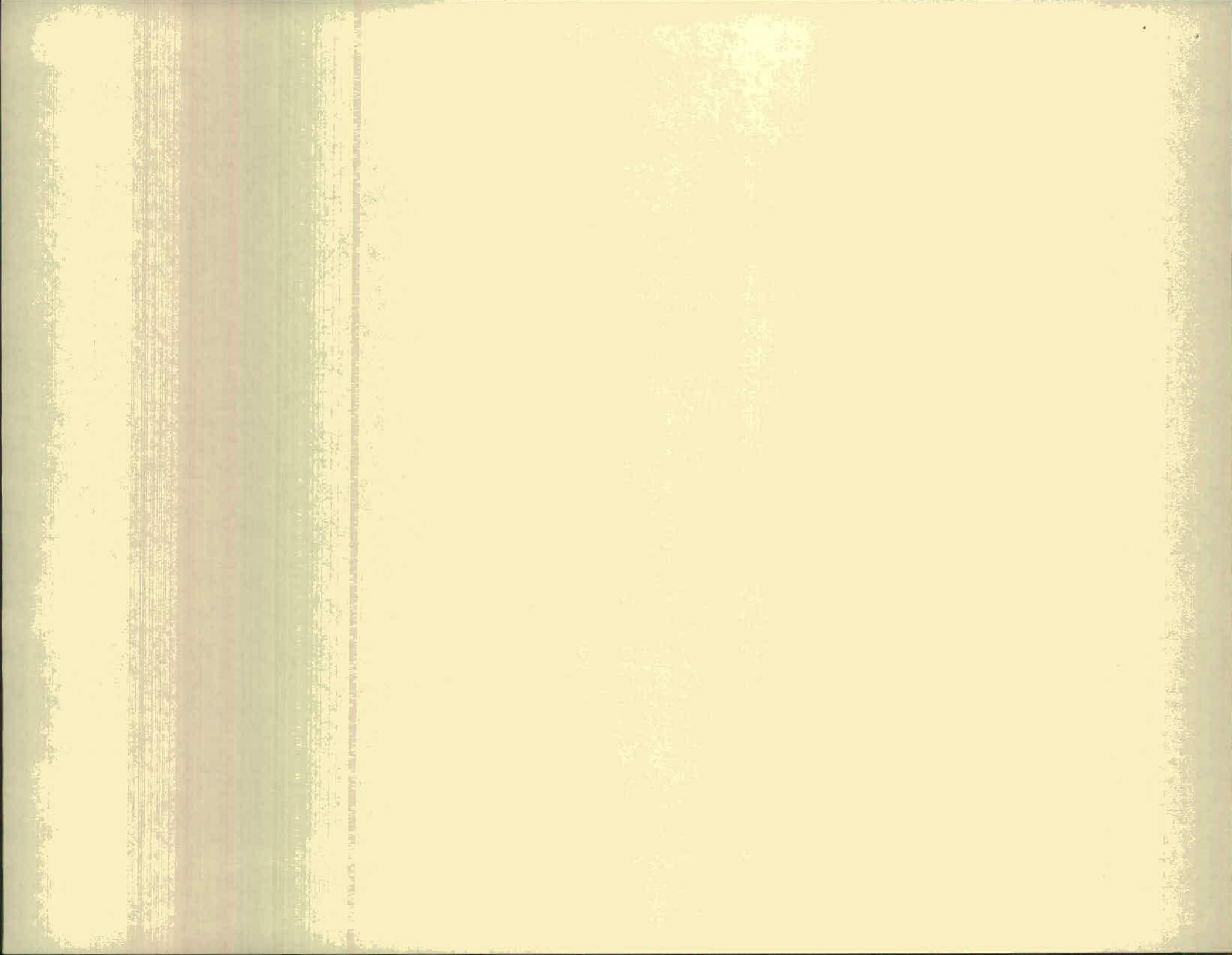
Washer

**

14-3-28

DAS
28
9-89

Location	Loc Qty	Loc Code
GA	110	
124392	110	
ST510a	3338	
m126319	2138	40X
m127813	1200	





DESIGN <i>90</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B* SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 *H*



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

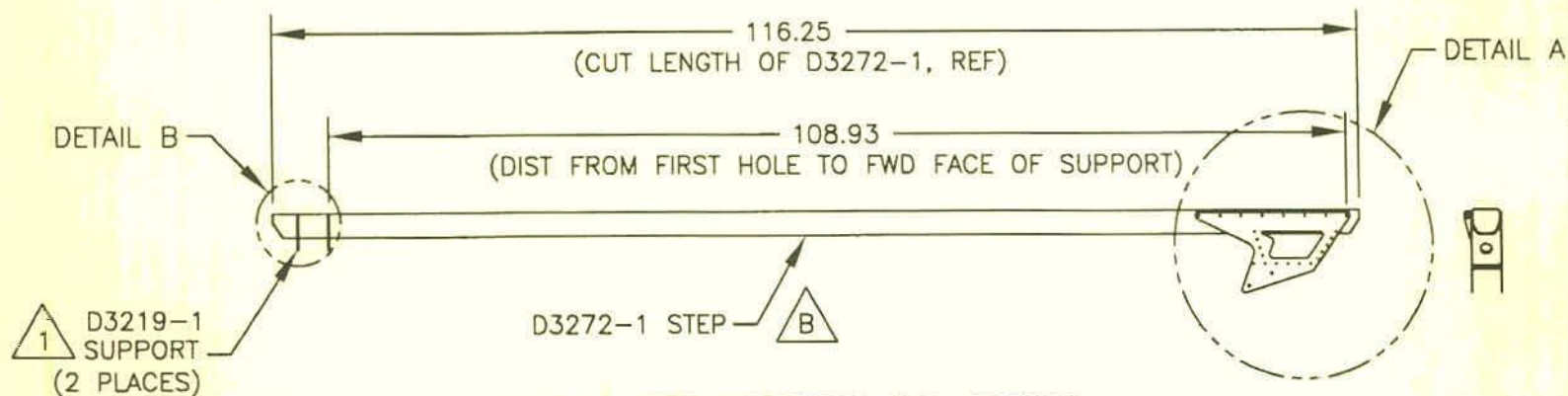
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14-01-15

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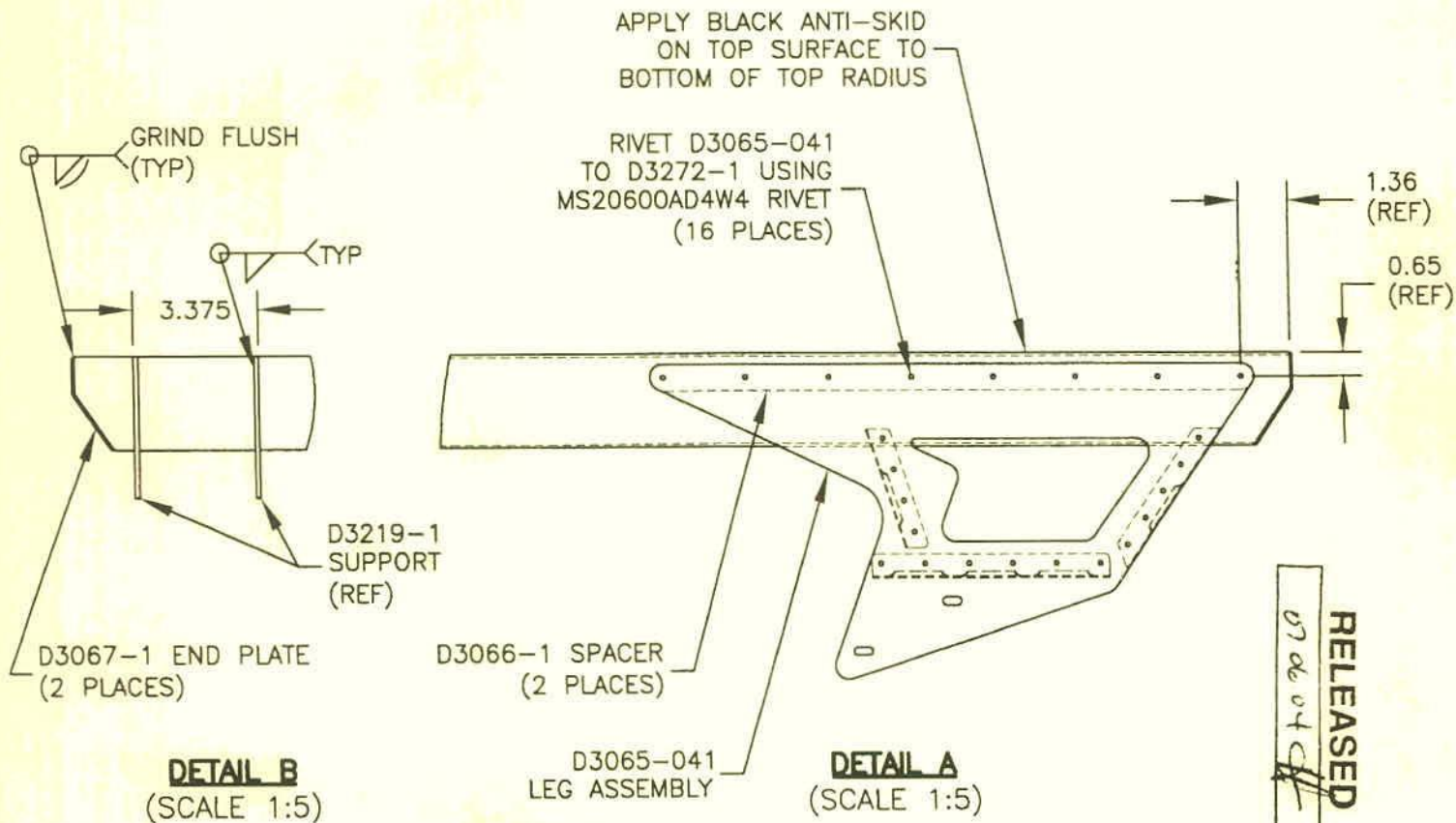
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DESIGN	APPROVED	DRAWING NO.	REV. B
CHECKED	APPROVED	D3272	SHEET 2 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

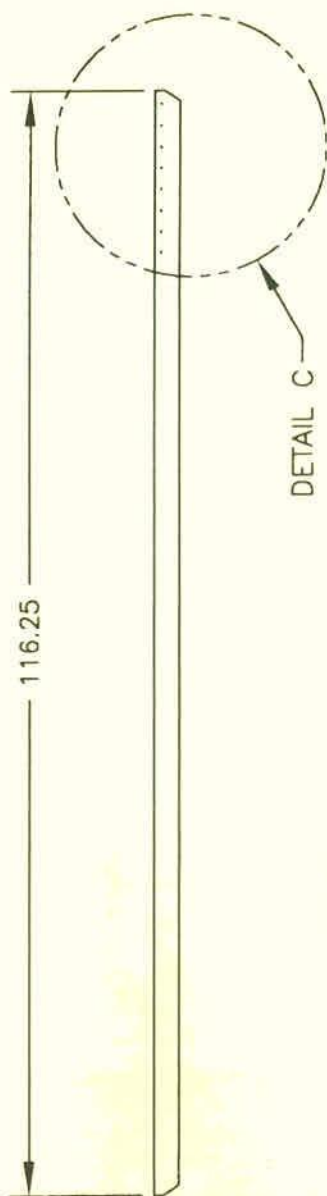




DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

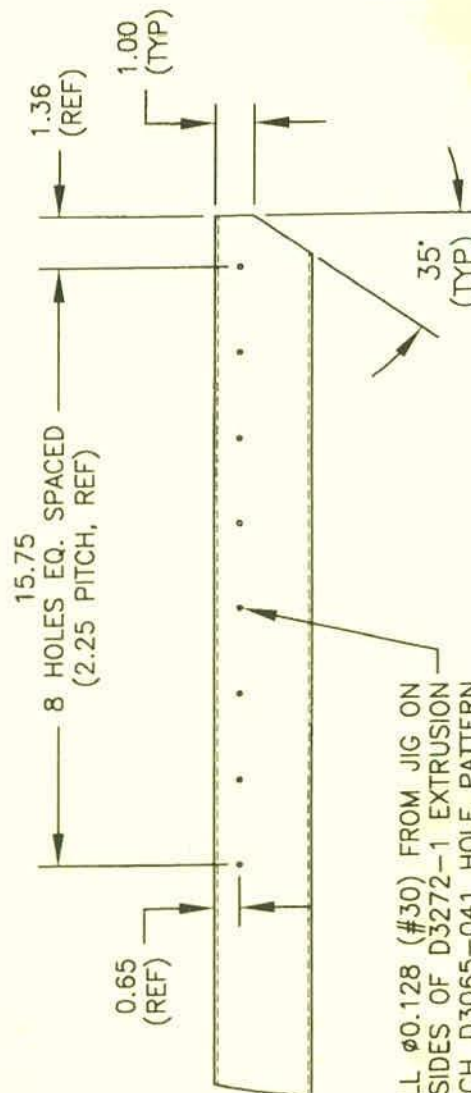
RELEASED

07 06 04 *[Signature]*



B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

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